












Date: Friday, 28/11/2008 3:05:34 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : REPLACEMENT WINDOW ASSEMBLY
Job Number : 43863	
Estimate Number : 11174	
P.O. Number :	Part Number : D3290041
This Issue : 28/11/2008 S.O. No. :	Drawing Number : D3290 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 42121	Material :
Written By :	Due Date : 20/12/2008 Qty : <u>3</u> Um : Each
Checked & Approved By : <u>JUD 08.12.01</u>	
Comment : Est. B 05.05.25 Added Step 11 KJ/JLM Est. C 06.05.09 Ecn 798 EC Est Rev:D Now on Waterjet 06-06-16 JLM Est rev E rev C dwg 07.09.28 EC verified by: DD	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation:
Description :	
1.0	M6061T6S040 6061-T6 .040 Sheet
	
	
Comment: Qty.: 3.9375 sf(s)/Unit Total : 39.3750 sf(s) M6061T6S040 Batch: <u>109396</u> <u>B 8-12-17</u>	
2.0	WATER JET FLOW WATER JET
	
	
Comment: FLOW WATER JET 1-Cut as per Dwg D3290 (use prog. for D3290-1) Dwg Rev: <u>E</u> <u>B 8-12-17</u> Prog Rev: <u>E</u> 2-Deburr if necessary <u>B 8-12-17</u>	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	
	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8 SECOND CHECK
	
	
Comment: SECOND CHECK <u>5 08/12/18</u> <u>(X9)</u>	
5.0	HAND FINISHING1 HAND FINISHING RESOURCE #1
	
	
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <u>FL 08/12/19</u> <u>(9)</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3290-041 PAR #: N/A Fault Category: Prod/PAB med & small ^{W.T.} NCR: Yes No DQA: D Date: 09/01/19
 Resolution: _____ Disposition: _____ QA: N/C Closed: D Date: 09/01/19

NCR: 43863		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/12/17	20	one from has damaged from the side around the corner. P.C. mat. was slightly damaged when received	<i>[Signature]</i>	Scrap & destroy no replace, already over on the W/O qty & finish off the stock of material.	<i>[Signature]</i> 8-12-18	<i>[Signature]</i> 08/12/18	<i>[Signature]</i>	<i>[Signature]</i> 08-12-18

NOTE: Date & initial all entries

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Job Number: 43863

Part Number: D3290041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M 109996



(9X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1-20
320 OF
1-50

M-L

08/12/19

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(09)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BK

09-01-13

8.0

D2126

Seal



Comment: Qty.: 6.5000 f(s)/Unit Total: 65.0000 f(s)

Locking Seal

Pick:

Qty Part Number Description

Batch

1 D2126-0780 Locking Seal

B-12154

BK

09-01-14

9.0

D32903

Window



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Window

Pick:

Qty Part Number Description

Batch

1 D3290-3 Window

43963

PC

5/12/22 (9)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3290

Clean D3290-041 and place in plastic wrap

BK

09-01-14

(9)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5/12/15

(48)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0

PACKAGING 1

PACKAGING RESOURCE #1



9x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 219

9/1/15

SD

13.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/16

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 09.01.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 43863
Description: Window Frame		Part Number: D3290-1
Inspection Dwg: D3290	Rev: C	Page 1 of 1

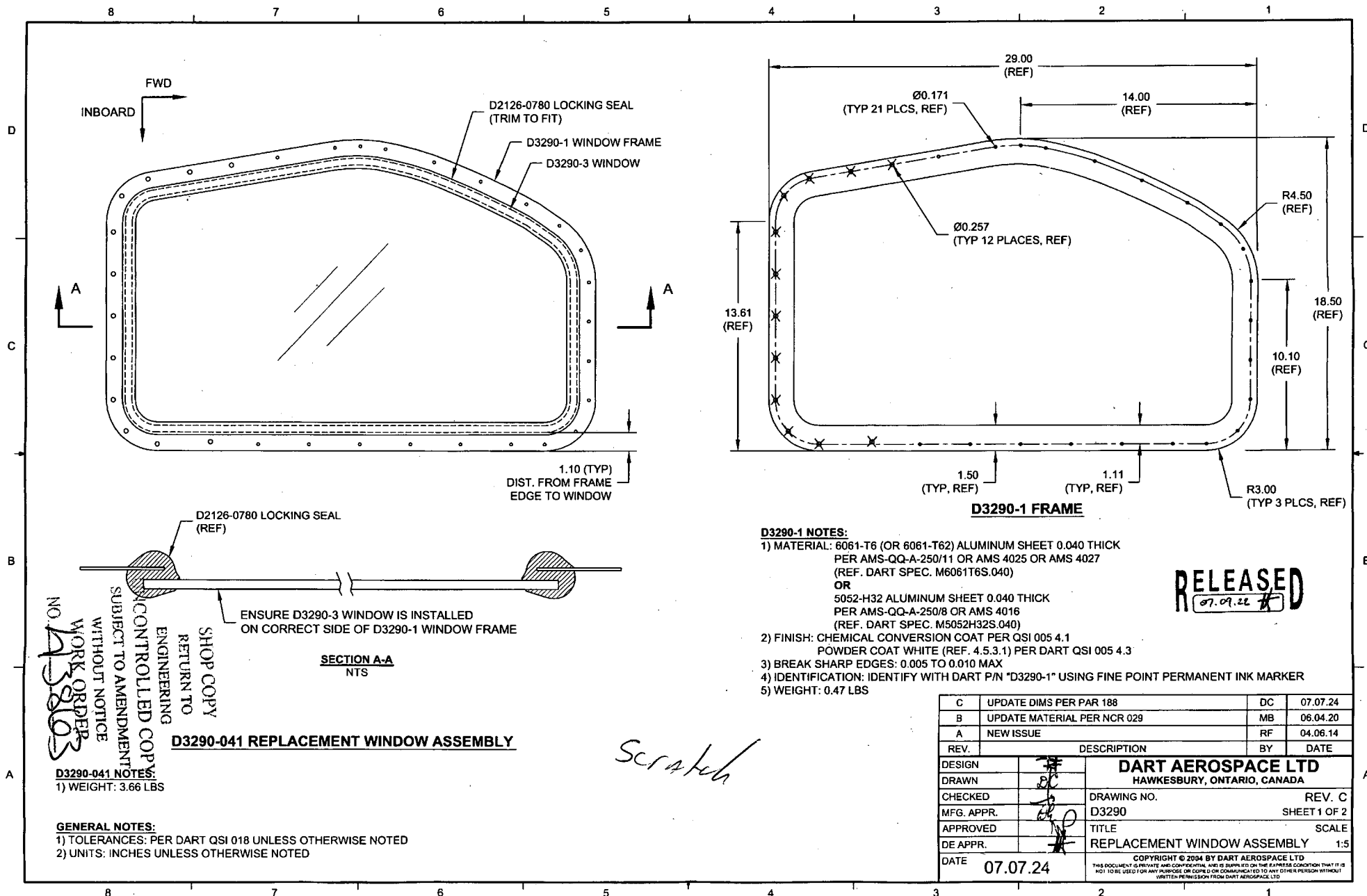
FIRST ARTICLE INSPECTION CHECKLIST

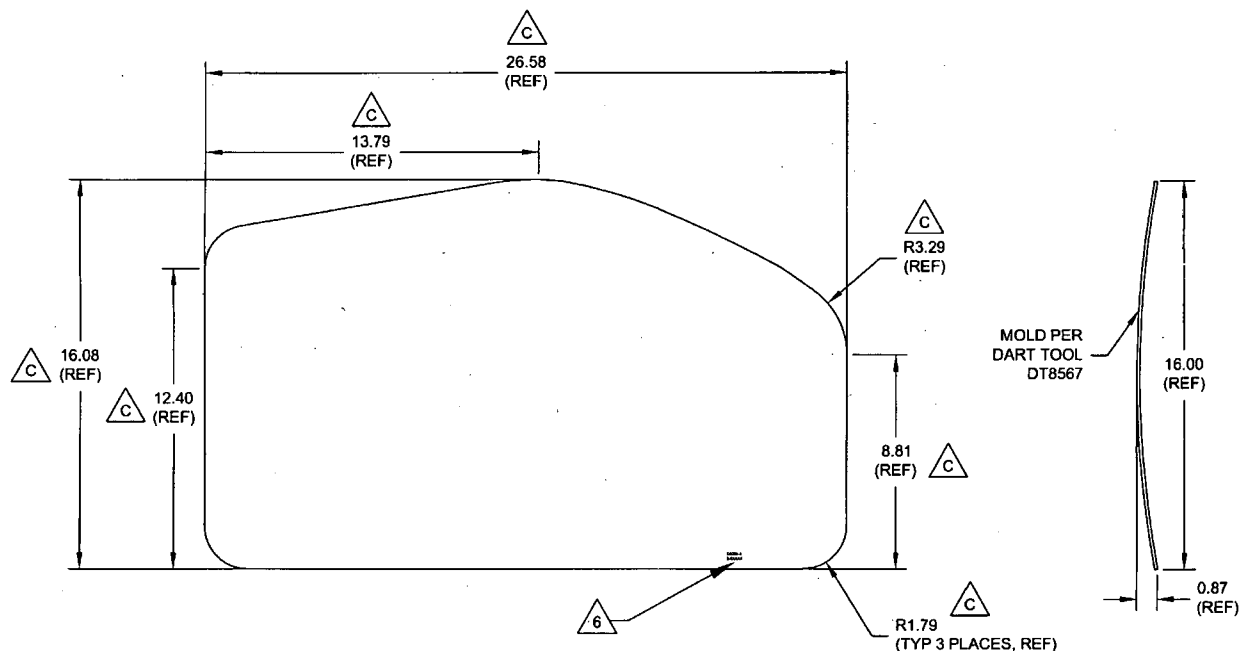
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.00	+/-0.030	29.00	✓			
14.00	+/-0.030	14.00	✓			
Ø0.171	+0.005/-0.001	0.171	✗			
1.50	+/-0.030	1.506	✗			
1.11	+/-0.030	1.113	✗			
10.10	+/-0.030	10.10	✓			
18.50	+/-0.030	18.50	✗			
0.040	+/-0.010	0.038	✗			
R3.00	+/-0.030	3.00	✗			
R4.50	+/-0.030	4.50	✗			
Ø0.257	+0.006/-0.001	0.259	✗			
13.61	+/-0.030	13.61	✗			

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 8-12-17	Date: 08/12/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue P/O D3290-041	KJ/JLM	
B	07.07.18	13.61 dimension removed	KJ/JLM	
C	07.09.28	Dimensions update per Dwg Rev C	KJ/EC/DD	BE











D3290-3 WINDOW

- D3290-3 NOTES:**
- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) REMOVE SHARP EDGES
 - 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
 - 7) WEIGHT: 1.87 +/- 0.42 LBS
 - 8) MOLD PER DART TOOL DT8567

RELEASED
07.09.22

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 13803

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3290	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		REPLACEMENT WINDOW ASSEMBLY 1:	
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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